

Work Order ID 157838

157838

Page 1

Monday, February 27, 2017 12:47:49 PM

Item ID: D3805-5

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Plate

Start Date: 3/1/2017

Start Qty: 10.00

10

Cust Item ID:

Required Date: 3/6/2017

Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

FEB 27 2017

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3805	D								
100		0.00							
1000									
Waterjet									
FLOW CNC Waterjet									
	Memo	0.19							
	1-Cut as per Dwg D3805								
	Dwg Rev: <u>0</u>								
	Prog Rev: <u>0</u>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC									
Quality Control									
	Memo	0.02							

10 DAS 46 17/03/01
9-89

10 DAS 46 17/03/01
9-89

Work Order ID 157838

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Page 3

Monday, February 27, 2017 12:47:49 PM

Item ID: D3805-5

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Plate

Start Date: 3/1/2017

Start Qty: 10.00

10

Cust Item ID:

Required Date: 3/6/2017

Req'd Qty: 10.00

10

Customer:

Reference:

Run Start *NR1*

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <u>WA001</u>	0.00							
150									
Packaging	Memo	0.02							
Packaging	LOCATION WA001								
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.17							
Quality Control									

DAS
21
9-89

MAR 09 2017

Picklist Print

Page 1

Monday, February 27, 2017 12:47:53 PM

Work Order ID: 157838

157838

Parent Item: D3805-5

D3805-5

Parent Item Name: Plate

Start Date: 3/1/2017

Required Date: 3/6/2017

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A 08-12-01 new issue EC verified by:DD

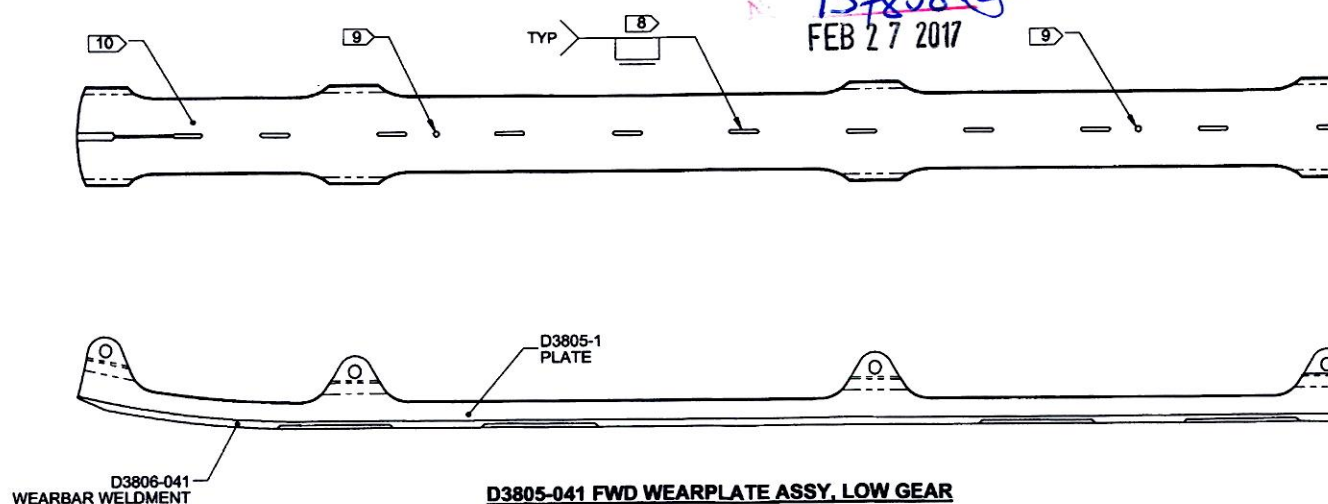
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S18GA		Purchased		No		100	sf	224.6440	1.587	16.70526	DAS 46 9-89	17/03/01	
M304S18GA													
304/316 .050 Sheet													

Location	Loc Qty	Loc Code
MAT020	223.84	
M135779	9.34	
M136036	18.4	
M136568	68.1	
M136687	64	17.7
M136790	64	
MAT20	0.804	
M134580	0.804	

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3805-041	FWD WEARPLATE ASSY, LOW GEAR
1	1	D3805-1	PLATE
2	1	D3806-041	WEARBAR WELDMENT

△

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
157238
FEB 27 2017



NOTES:

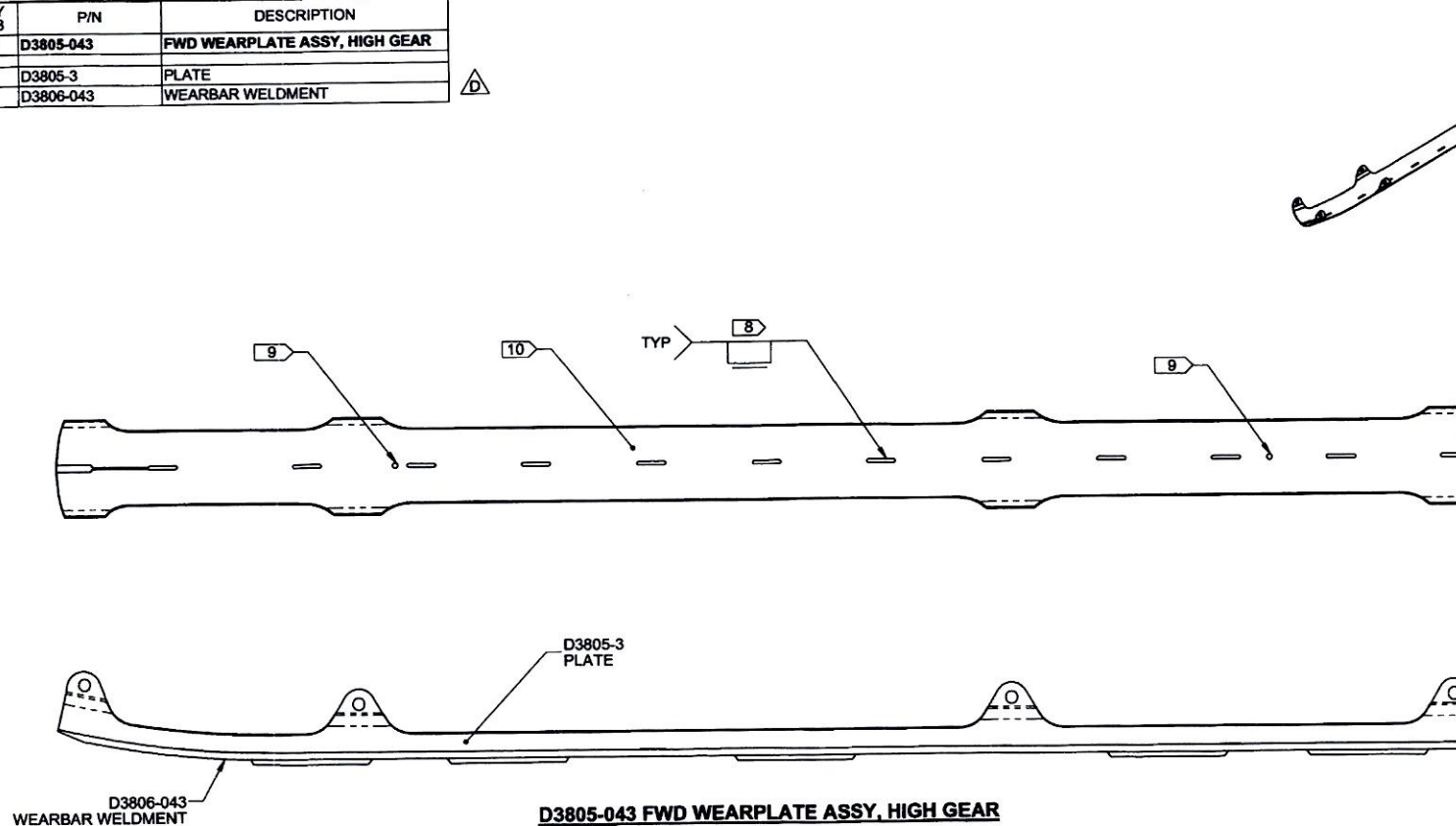
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 3.65 lbs
- 8) WELDING: PER QSI 004
- 9) AFTER WELDING, TRANSFER DRILL $\phi 0.19$ THRU THE WEARBAR FROM THE PLATE
- 10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020 - 0.040 THICK, PER DART QSI 005 4.9.

D	HARDCOAT MOVED TO D3806. REASON: ROBOTIC PROCESS. GENERAL UPDATE TO CURRENT STANDARDS. TOLERANCES FOR -1F, -3F, -5F & 7F UPDATED.	AJS	16.02.25
C	REMOVE ITEMS 19, 20, 21, 22 AND 32 FROM BOM (ZN C4-1). REVISE NOTE 11, SHEETS 283 (ZN A8-2, B2-2, B6-2, A8-3, B2-3, B6-3)	DB	13.10.04
B	REVISED D3805-1F/-3F TO EASE MANUFACTURABILITY (ADDED CUTOUT AT FWD END OF PLATE PER PAR11-106) AND RE-ORGANIZED NOTES SHEETS 2 & 3	MB	11.09.16
A	NEW ISSUE	MB	08.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE USA, INC. EUGENE, OR	
DRAWN	AJS		
CHECKED	ML	DRAWING NO.	REV. D
MFG. APPR.	DD	D3805	SHEET 1 OF 9
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	WEARPLATE ASSY	NTS
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2016-03-31
ENL-553

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ITEM	QTY -043	P/N	DESCRIPTION
	X	D3805-043	FWD WEARPLATE ASSY, HIGH GEAR
1	1	D3805-3	PLATE
2	1	D3806-043	WEARBAR WELDMENT



D3805-043 FWD WEARPLATE ASSY, HIGH GEAR

NOTES:

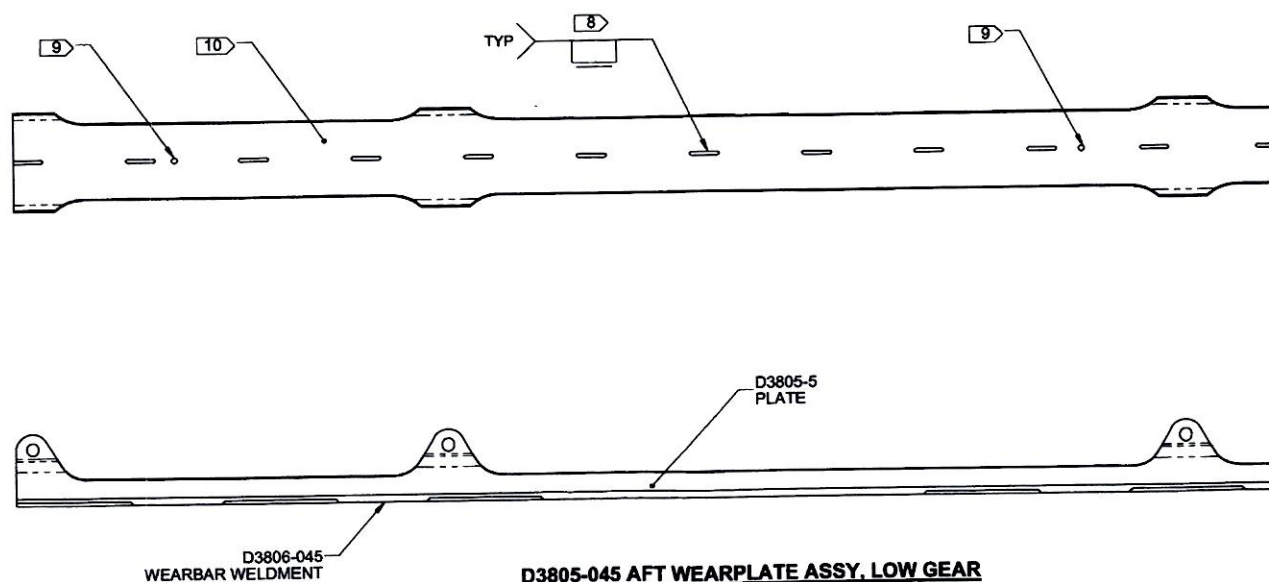
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- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 §.1
- 7) WEIGHT: 4.65 lbs
- 8) WELDING: PER QSI 004
- 9) AFTER WELDING, TRANSFER DRILL $\phi 0.19$ THRU THE WEARBAR FROM THE PLATE
- 10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020 - 0.040 THICK, PER DART QSI 005 4.9.

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ITEM	QTY	P/N	DESCRIPTION
	X	D3805-045	AFT WEARPLATE ASSY, LOW GEAR
1	1	D3805-5	PLATE
2	1	D3806-045	WEARBAR WELDMENT



NOTES:

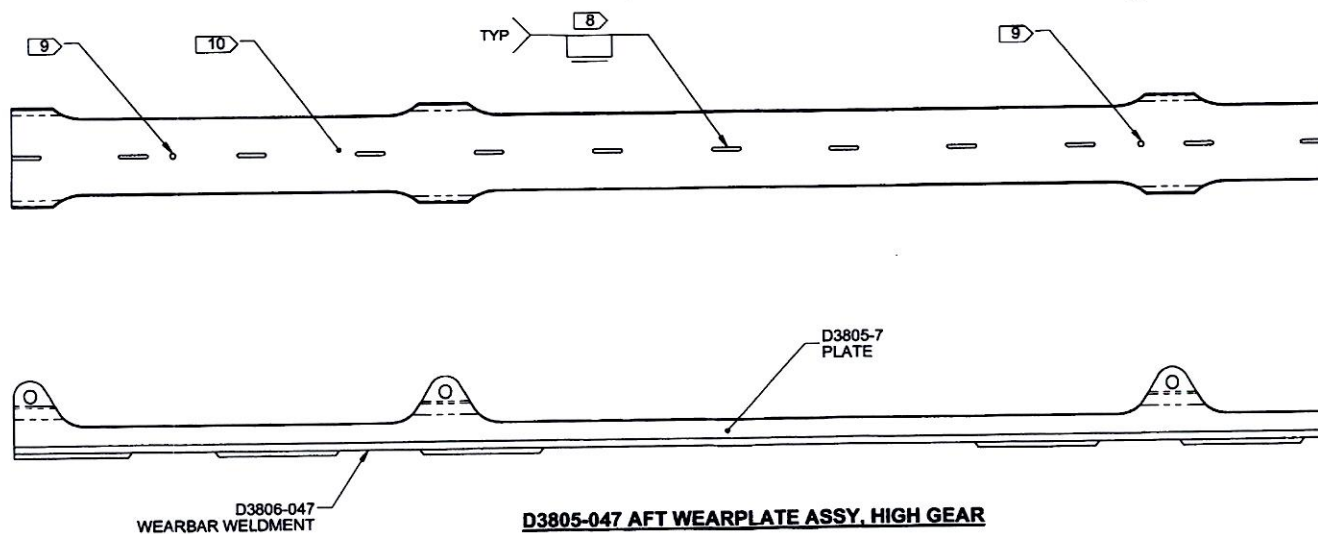
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- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 3.63 lbs
- 8) WELDING: PER QSI 004
- 9) AFTER WELDING, TRANSFER DRILL $\varnothing 0.19$ THRU THE WEARBAR FROM THE PLATE
- 10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020 - 0.040 THICK, PER DART QSI 005 4.9.

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ITEM	QTY -047	P/N	DESCRIPTION
	X	D3805-047	AFT WEARPLATE ASSY, HIGH GEAR
1	1	D3805-7	PLATE
2	1	D3806-047	WEARBAR WELDMENT



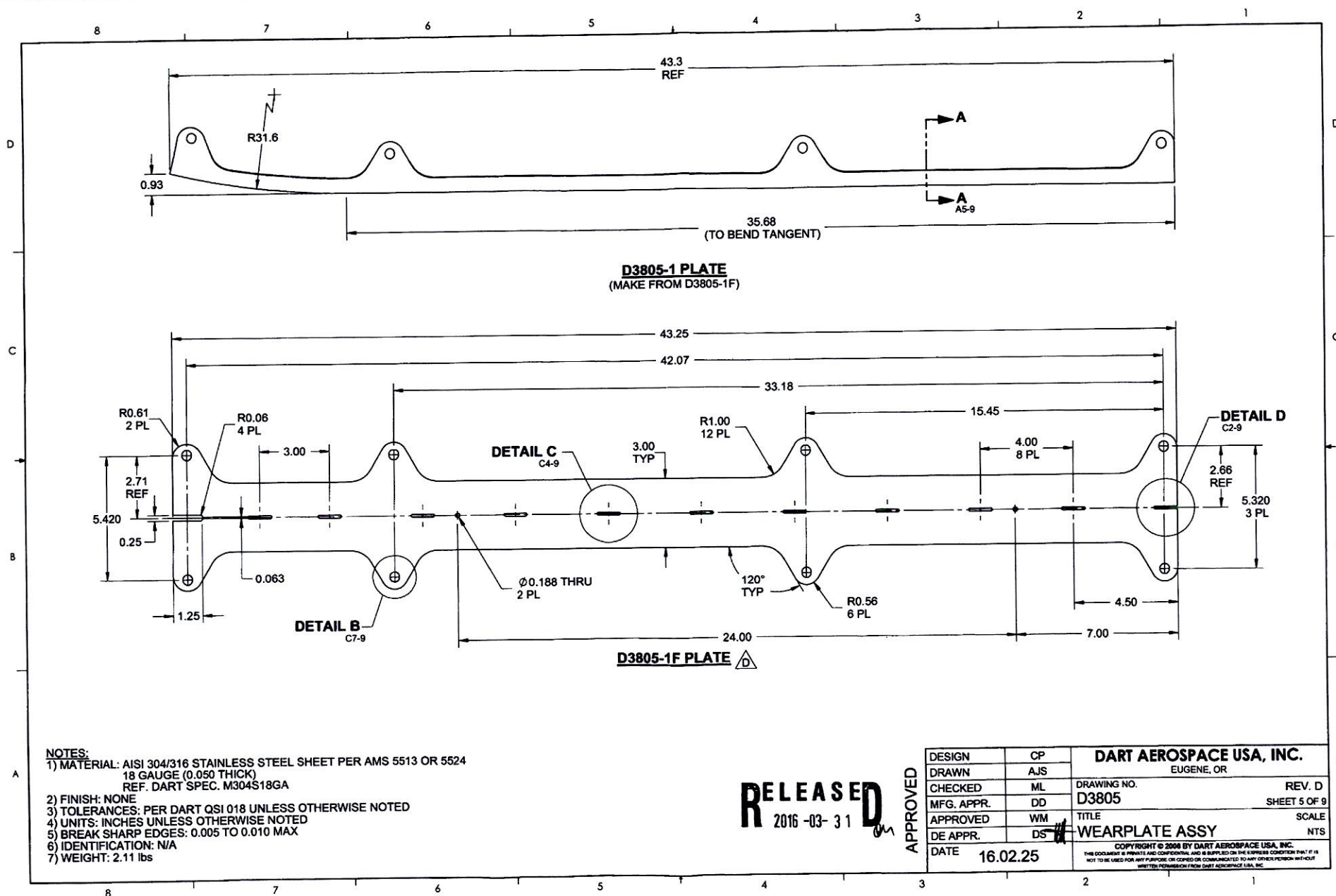
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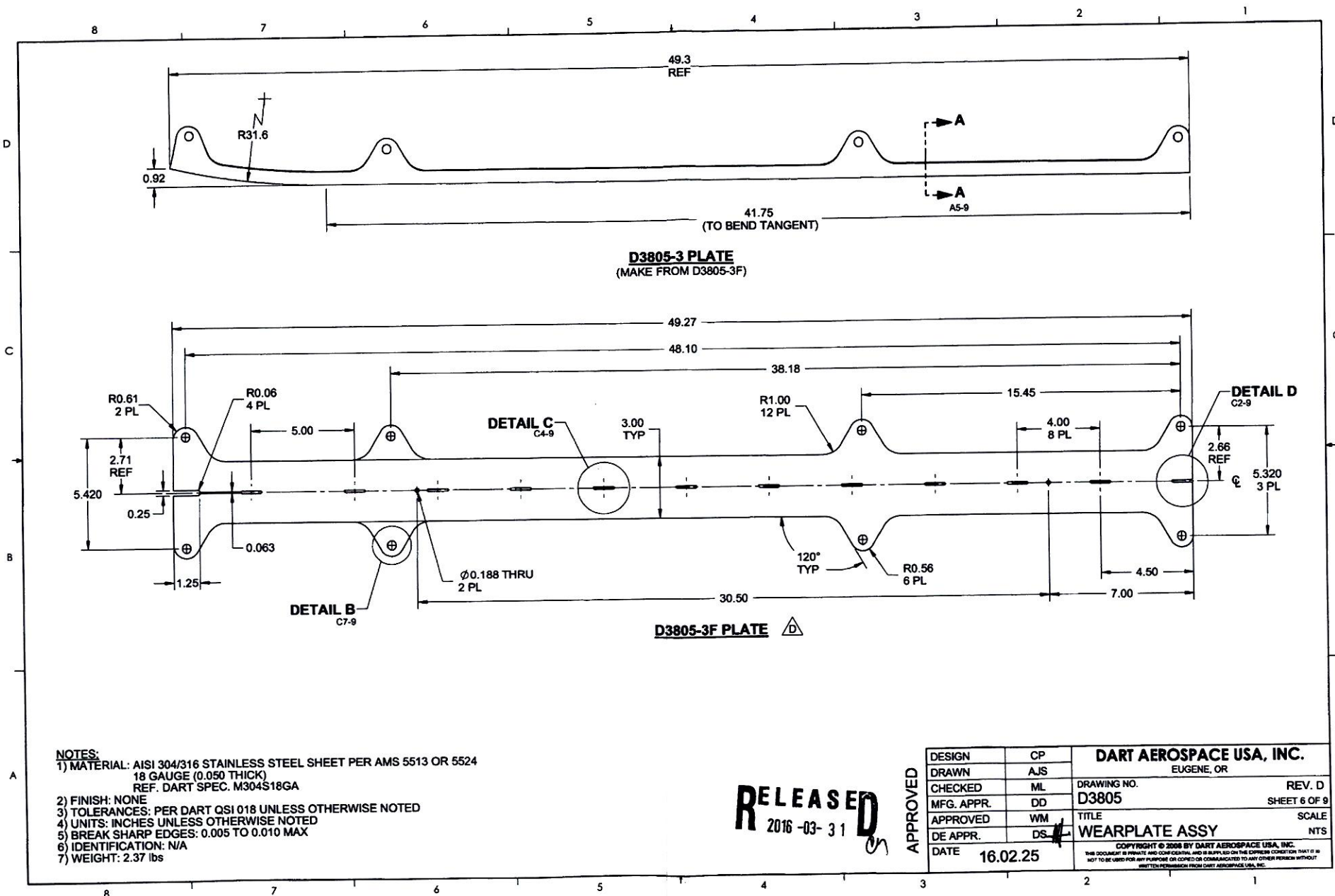
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 4.29 lbs
- 8) WELDING: PER QSI 004
- 9) AFTER WELDING, TRANSFER DRILL $\varnothing 0.19$ THRU THE WEARBAR FROM THE PLATE
- 10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING, 0.020 - 0.040 THICK, PER DART QSI 005 4.9.

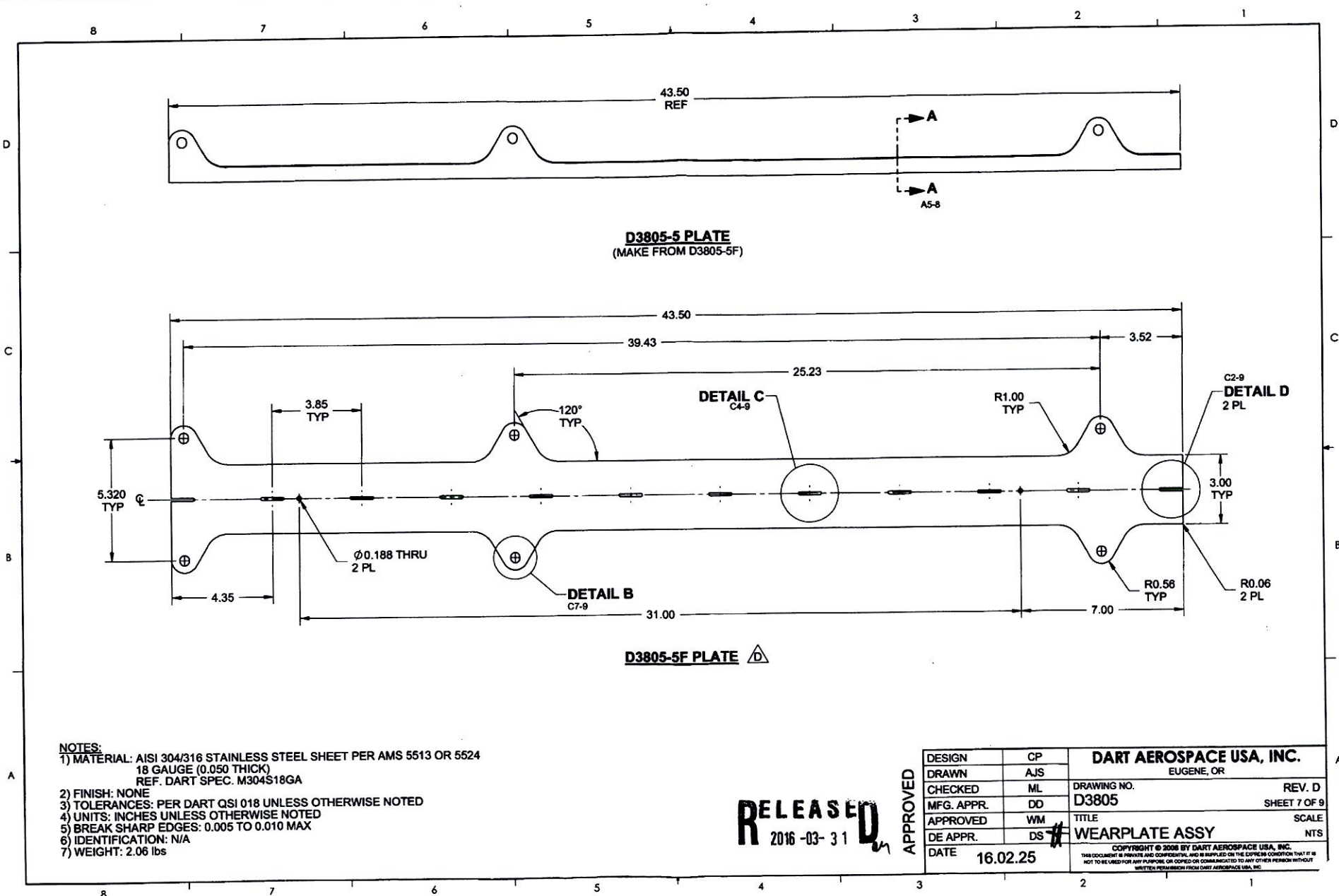
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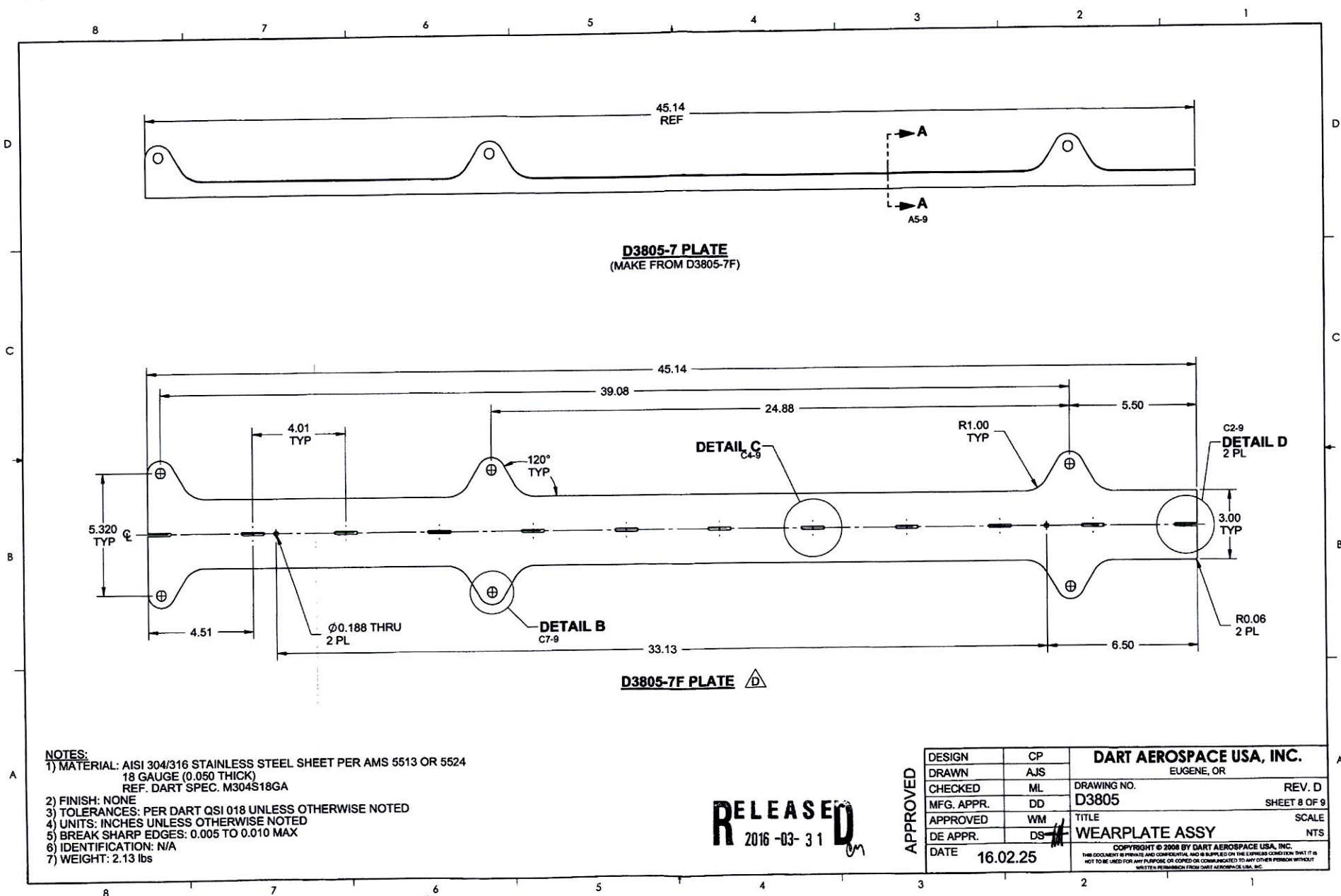
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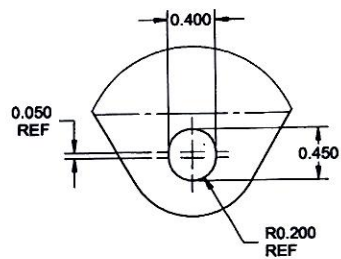
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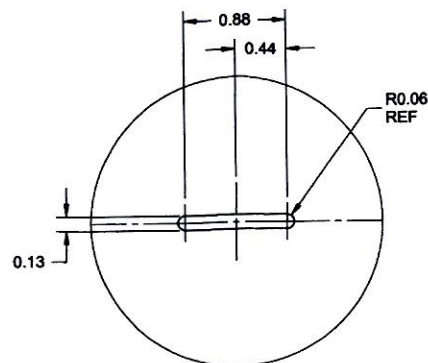




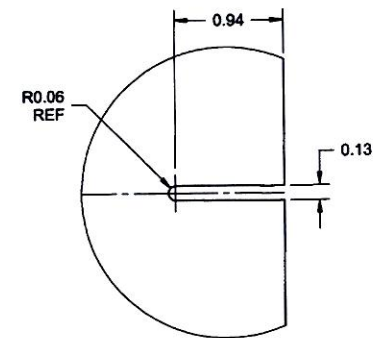




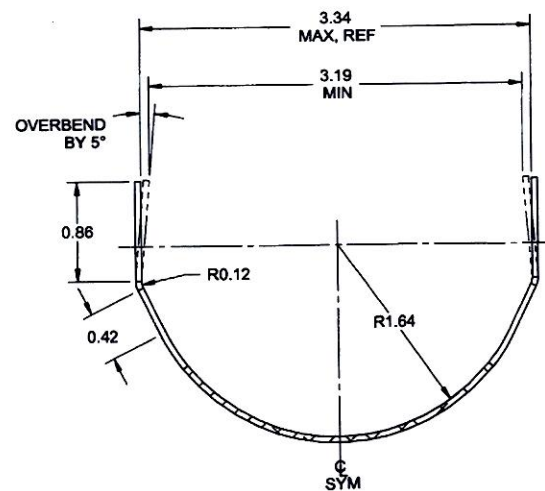
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B7-5
B7-6
B5-7
B5-8



DETAIL C
SLOT DETAIL TYP
SCALE 4X
C5-5
C5-6
C4-7
C4-8



DETAIL D
SLOT DETAIL TYP
SCALE 4X
C1-5
C1-6
C1-7
C1-8



SECTION A-A
SCALE 4X
D3-5
D3-6
D3-7
D3-8

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2016-03-31

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